



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3492-3
Job Sheet 186830



Part No: D3492-3

Job Qty: 120 ea

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	120 Ea		11/30/18	0.00	0.00	Start Up Machining-2		JRD 18/12/16
100	Hardinge	120 pcs		11/30/18	0.00	4.49	Hardinge		" "
120	QC	120 pcs		11/30/18	0.00	0.00	QC8		JRD 18/12/19
130	HandFinish	120 pcs		11/30/18	0.00	0.41	HandFinish1		D.R 18/12/19
135	Outsource	120 pcs		11/30/18	0.00	0.00			
140	Powdercoat	120 pcs		11/30/18	0.00	0.24	Powdercoat1		BR 18-12-19
145	Packaging	120 pcs		11/30/18	0.00	0.00			U/R
150	QC	120 pcs		11/30/18	0.00	0.00	QC3		D 18-12-20
160	Packaging	120 pcs		11/30/18	0.00	0.00	Packaging3-1	FP-001	JL 18-12-20
170	QC21-SA	120 Ea		11/30/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Folio FA632 & Dwg D3492

Descriptions: 140 - (Flat End Only)

160 - LOCATION : FP001

M 188951 START: 3:15 O.U.T. 320° FINISH: 5:45.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.750	6061-T6 Round Bar .750"	7.0800 ft (.059 ea)	90-Start up Operation	5110759

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.750	7	62	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.750inches ± 0.010	0.760 0.740		
2	Plug	0.582inches + 0.000 - 0.002	0.582 0.580		
3	Plug	0.045inches + 0.000 - 0.002	0.045 0.043		
4	Plug	0.060inches ± 0.005	0.065 0.055		



DART
AEROSPACE

QA Closed: Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER :									

5	Plug	0.060inches $\pm$ 0.005	0.065 0.055
6	Plug	0.500inches $\pm$ 0.010	0.510 0.490
7	Plug	0.090inches + 0.000 - 0.002	0.090 0.088

Plex 11/22/18 7:11 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Description Work Order Deviation Dart Aerospace Ltd. 1270 Aberdeen Street Hewkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 12/12/18 Container No: S137512 Part: D3492 - 3 Job No: 186830 Serial No/Batch: S137512 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's								Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval 																																																																																																																															
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